

Date: Tuesday, 2/26/2008 8:02:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRAP
Job Number : 37631	
Estimate Number : 10729	
P.O. Number :	Part Number : D23245
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D2324 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36749B	Material :
Written By :	Due Date : 3/17/2008 Qty: 50 Um: Each
Checked & Approved By : <u>AF 08 02 26</u>	
Comment : Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0184 sf(s)/Unit Total : 0.9200 sf(s)
 304/316 .063 Sheet **106860 B 8-3-4**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2324
 Dwg Rev: C
 Prog Rev: C

B 8-3-4

2-Deburr if necessary

EB08/03/06

(51)
(54)
(49)
15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**B 8-3-4**

Comment: DIMENSIONAL CHECK
 Inspect dimensions per template D2324-5T1

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EB08/03/06

counts
(54)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: **26**

8/3/6 54**(54x)**

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2324-5 PAR #: N/A Fault Category: Prod / Pass' model small NCR: Yes No DQA: (1) Date: 08/03/07
 QA: N/C Closed: 49 Date: 08/03/10

NCR: <u>37631</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/06	# 80	two parts scrap End of the sheet. RC improper placement on the water jet	<i>[Signature]</i>	Scrap and Destroy and Replk Qty (12)	<i>[Signature]</i> 8-3-06	<i>[Signature]</i> 08/08/06	<i>[Signature]</i>	<i>[Signature]</i> 08/08/06

NOTE: Date & initial all entries

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User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 37631

Part Number: D23245

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(54)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/07

Job Completion



2008/3/07

(54)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

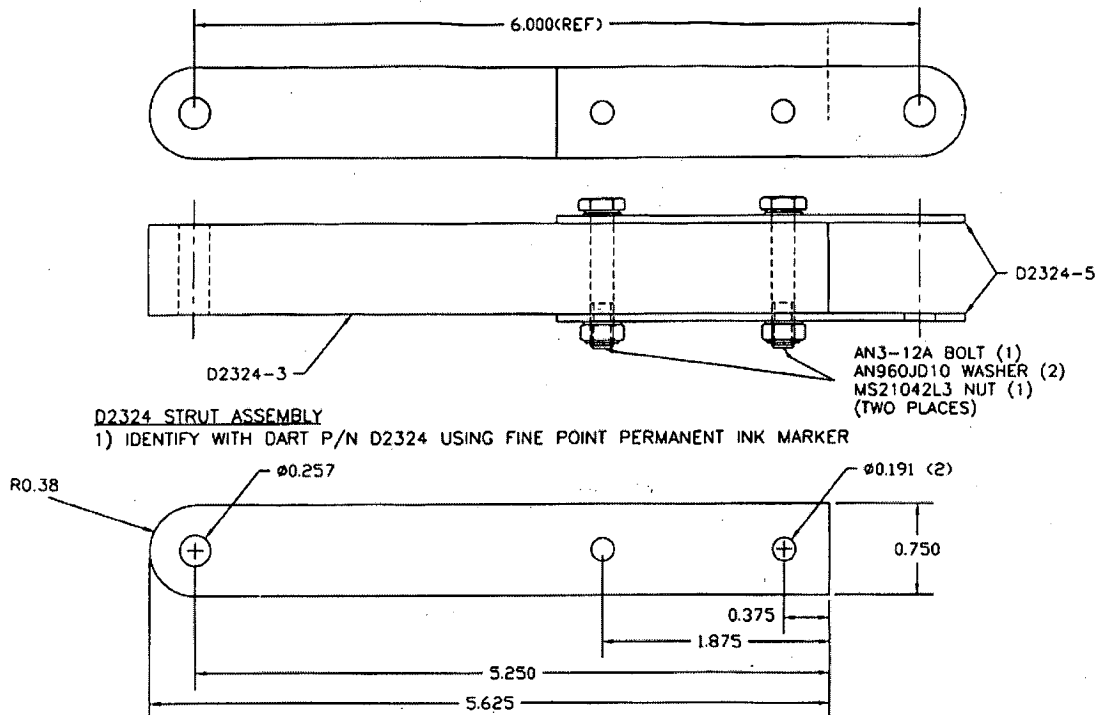

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

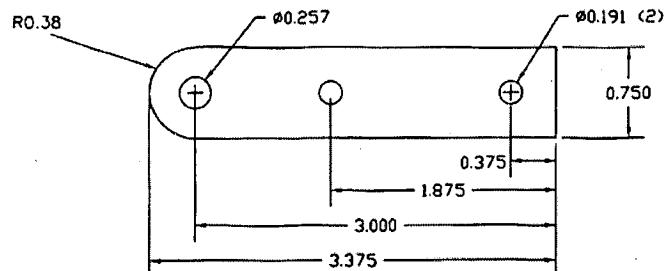
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 **D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SV
NG
COPY
UNCO
R'B
NOTICE
MARK ORDER
N.I. 37631